

Work Order ID 51646

August 27, 2009 8:28:48 AM

Page 1

Item ID: D3536-41

Revision ID: A

Item Name: Gasket

Start Date: 8/27/09 Start Qty: 5.00

Required Date: 9/04/09 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: *[Signature]*

QC:

Date: *09-8-27* Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.00

I-Cut as per Dwg D3536 Dwg Rev: A IProg Rev: A 2-
Deburr if necessary

B 9-9-9

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-9-9

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

27 8/27/09

(42)

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3536-41

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gasket

Start Date: 8/27/09 Start Qty: 5.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *F-1218*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PC 9/8/10 (12)

09/09/11

MF 09-09-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51646

Parent Item: D3536-41RevA

Parent Item Name: Gasket

Comments:

Start Date: 8/27/09

Required Date: 9/04/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	638.9541	3.5811	8.5946		



NEOPRENE SHEET 0.063

HB 99-9

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	638.9540585	
111469	71.1	
111853	167.854059	
112508	400	

NONE
NONE
112508

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	51646
Description: Gasket		Part Number:	D3536-41
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.98	+/-0.030	27.980	*			
25.08	+/-0.030	25.08	*			
18.50	+/-0.030	18.50	*			
15.00	+/-0.030	15.00	*			
12.47	+/-0.030	12.47	*			
8.97	+/-0.030	8.97	*			
6.93	+/-0.030	6.938	*			
3.43	+/-0.030	3.43	*			
2.00	+/-0.030	2.001	*			
4.00	+/-0.030	4.002	*			
Ø0.19	+0.005/-0.001	.190	*			
3.90	+/-0.030	3.902	*			
1.88	+/-0.030	1.888	*			
0.30	+/-0.030	.301	*			
0.30	+/-0.030	.304	*			
0.063	+/-0.010	.066	*			

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	9-9-9	Date:	01/01/02	Date:	N/A

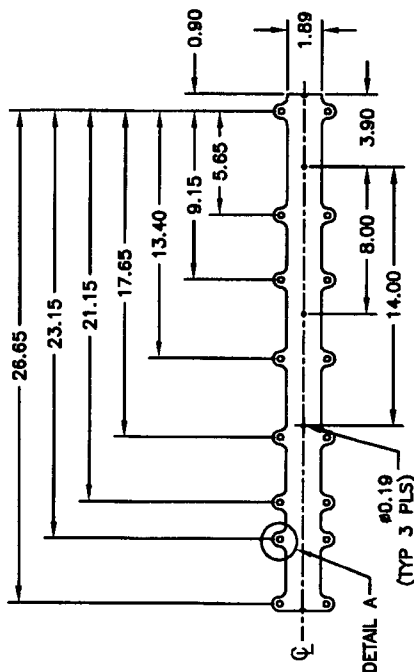
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE



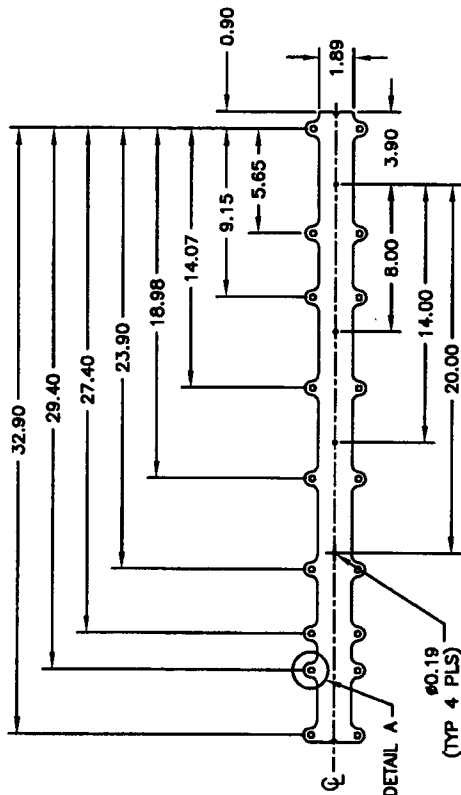
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CHECKED PH	APPROVED 	DRAWING NO. D3536	REV. A SHEET 1 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10
A	06.10.25	NEW ISSUE	

RELEASED

07.02.12



D3536-11 GASKET



D3536-13 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 - 7) SEE PAGE 6 FOR DETAILS AND SECTION

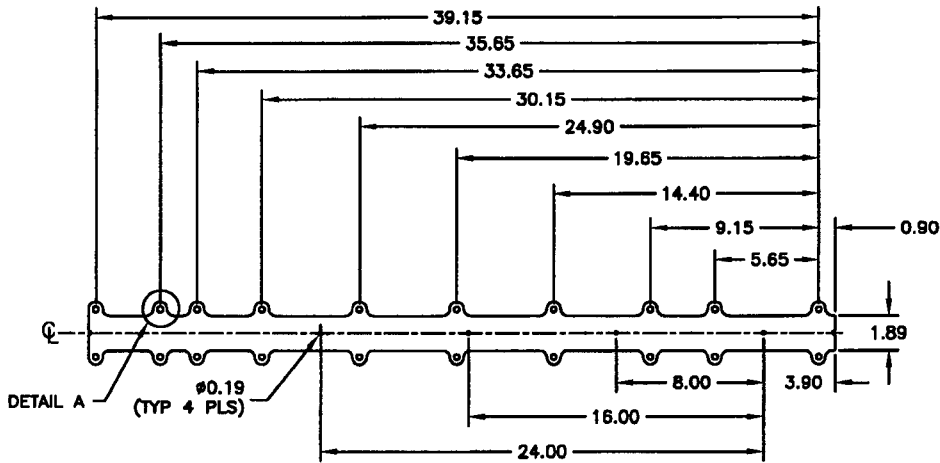
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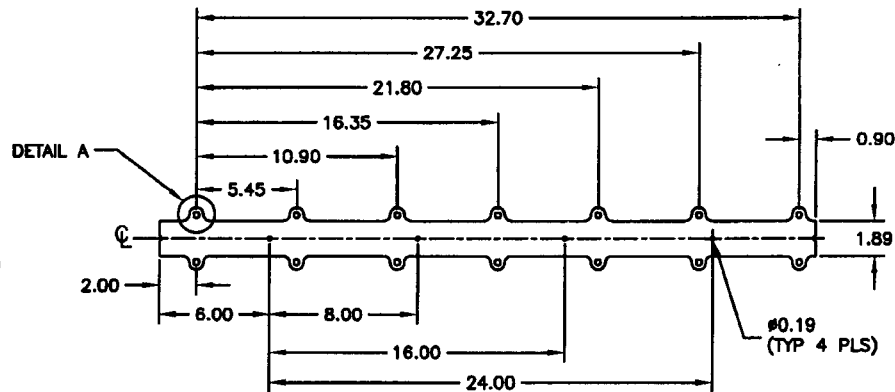
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DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 2 OF 6
				SCALE
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D3536-15 GASKET



D3536-21 GASKET

51646

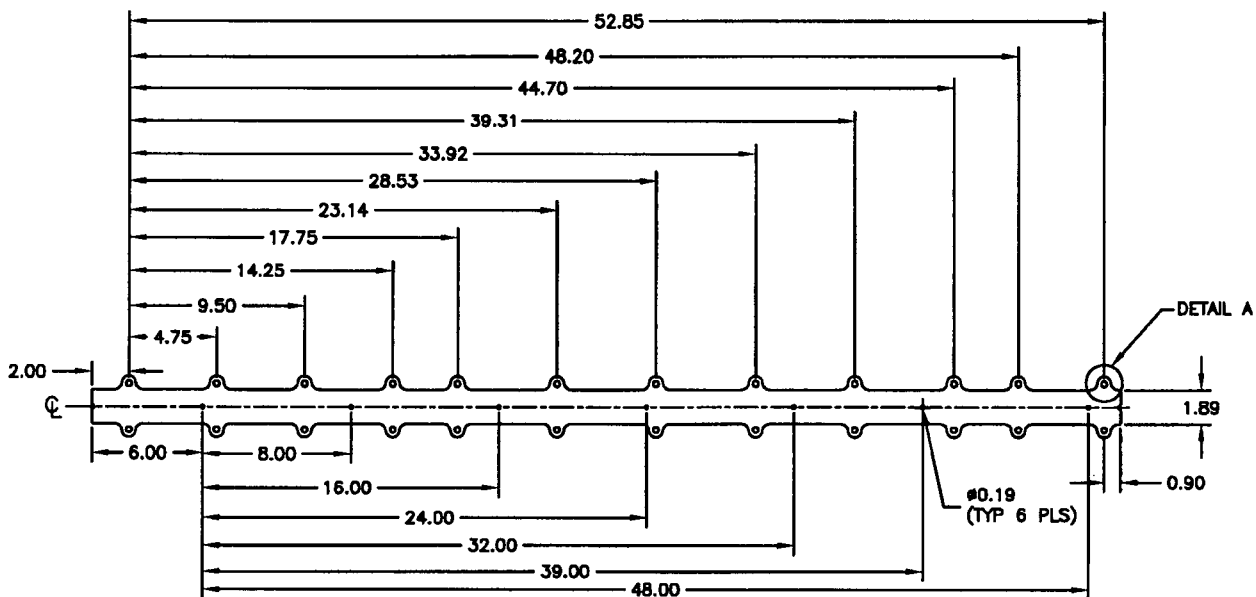
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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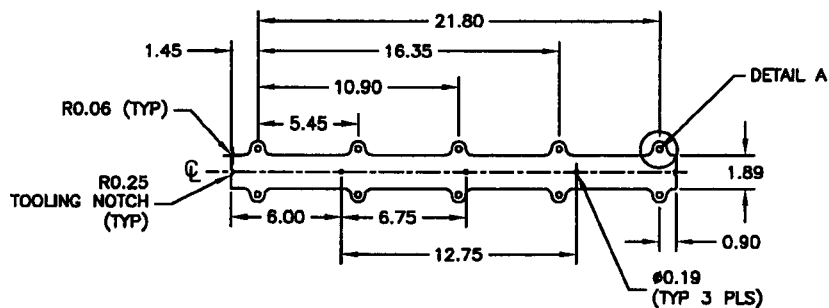
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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D3536-23 GASKET



D3536-25 GASKET

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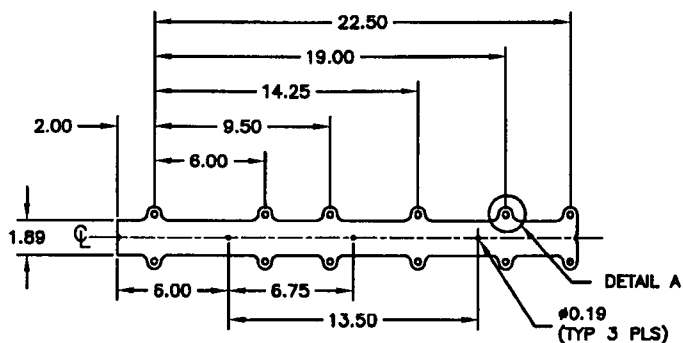
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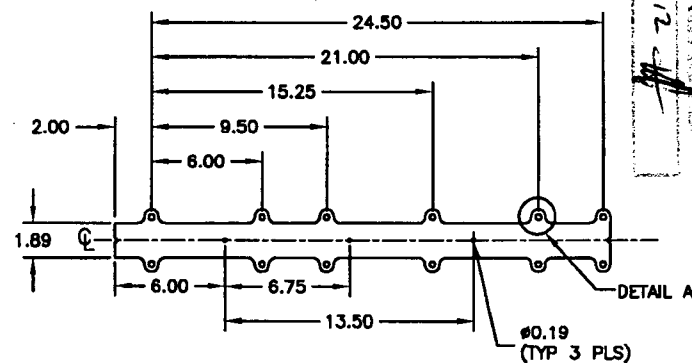
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DATE 06.10.25	TITLE GASKET	SHEET 4 OF 6	SCALE 1:10

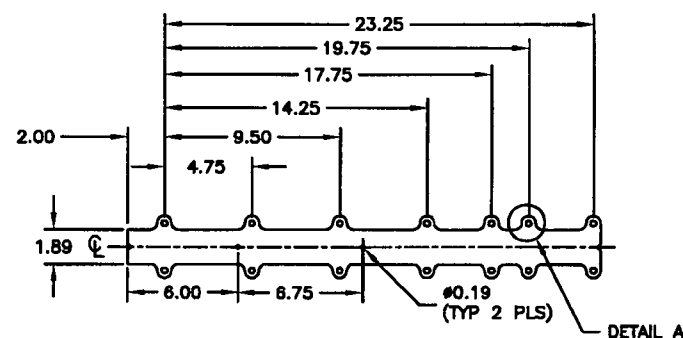
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D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

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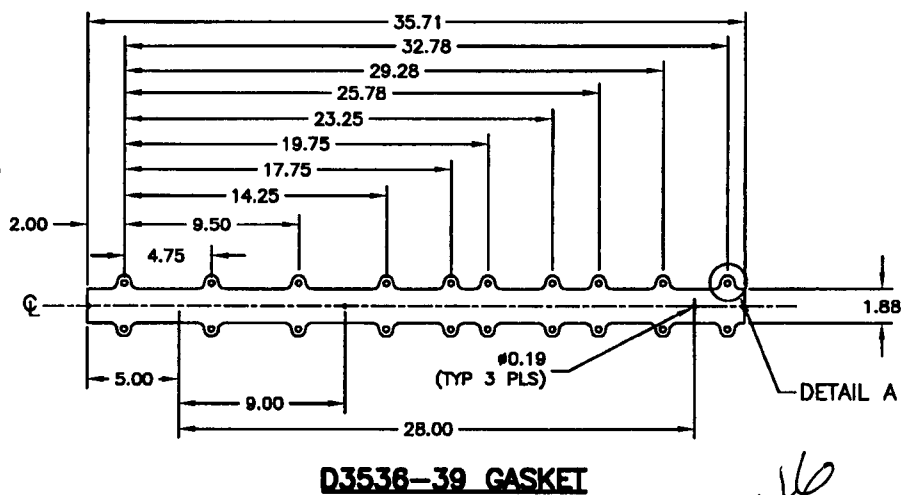
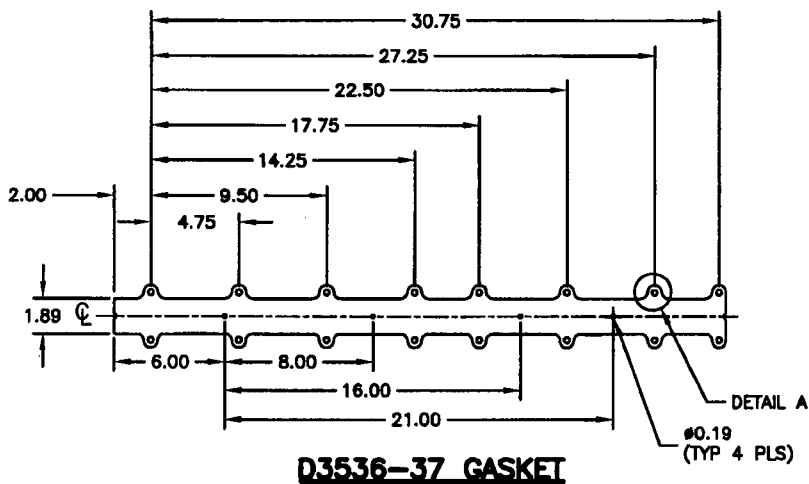
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		TITLE	GASKET	SHEET 5 OF 6
				SCALE 1:10

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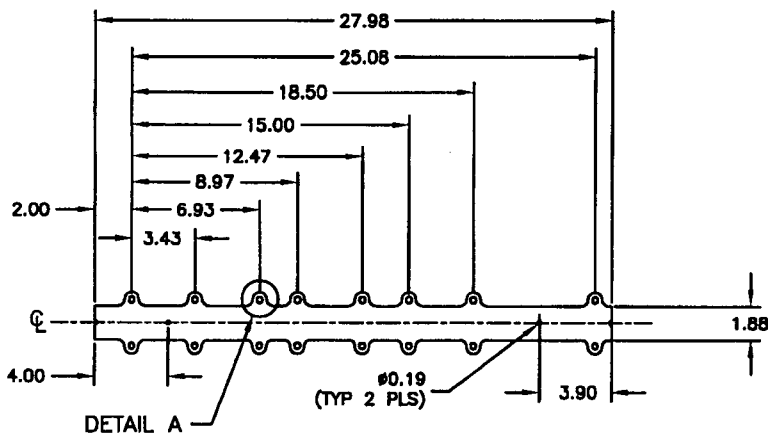
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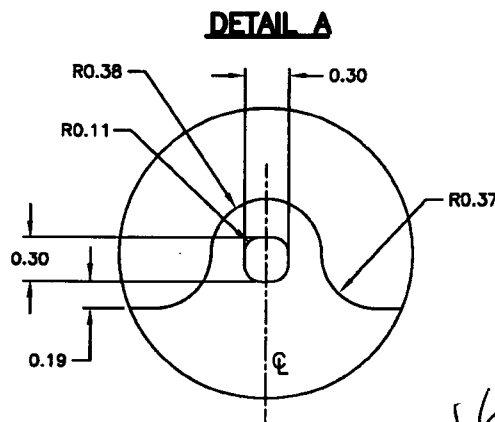
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D3536-41 GASKET



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